

Date: Thursday, 2/9/2006 1:52:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
 Job Number : 25778
 Estimate Number : 12136
 P.O. Number : *N/A*
 This Issue : 2/9/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 25777
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.02.10
 Comment : est rev. A 01.02.01 new issue EC

Part Number : D206731041
 Drawing Number : IIN-D206-731 *pg 4,6*
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 3/15/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33355 spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓
 qty Part Number Description batch
 1 D3335-5 spring *325909*

Cpl 06.12.07

2.0 D3353042 LUG ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

→
 qty Part Number Description batch
 1 D3353-042 LUG ARM WELDMENT *325807*

Cpl 06.12.07

3.0 D3354041 LEFT ARM WELDMENT



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓
 qty Part Number Description batch
 1 D3354-041 Left Arm Weldment *325910*

Cpl 06.12.07

4.0 D33561 pin



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓
 qty Part Number Description batch
 1 D3356-1 pin *325912*

Cpl 06.12.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
<i>06-12-12</i>	<i>4.1</i>	Add D3354-043 Qty 1 Perman. chg	<i>E</i>	<i>06-12-11</i>			<i>06-12-12</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25778

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	B25804

PPL 06.12.07

6.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	M101058

PPL 06.12.07

7.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	M17413

PPL 06.12.07

8.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	M16362

PPL 06.12.07

9.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	M19278

PPL 06.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25778

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516L	Washer	M17619

EPL 06.12.07

11.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	SNF-34	1/8" Cotter Pin 2" long	M16301

EPL 06.12.07

12.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	M102171

EPL 06.12.07

13.0

SNF34

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	1/8" Cotter Pin 2" long	M16354

Sloten Nut M102935

EPL 06.12.07

14.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	M16588

EPL 06.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: IP Date: 06/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25778

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	M16362

06-12-07

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

06-12-12

①

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 12-12

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 321

06/12/12

①

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/12/12

Job Completion



06/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-12-11	160	2 x D3353-042 B 25603 need to be re-worked due to the D3353-9 stop was installed backwards. R.C. Human error missed upon inspection.		Removed, re-installed correctly 331004 re-powder coat as per 051005	06/12/12 a.m.	06/12/12		06-12-11

NOTE: Date & initial all entries

PRELIMINARY ISSUE

4.0 PARTS LIST

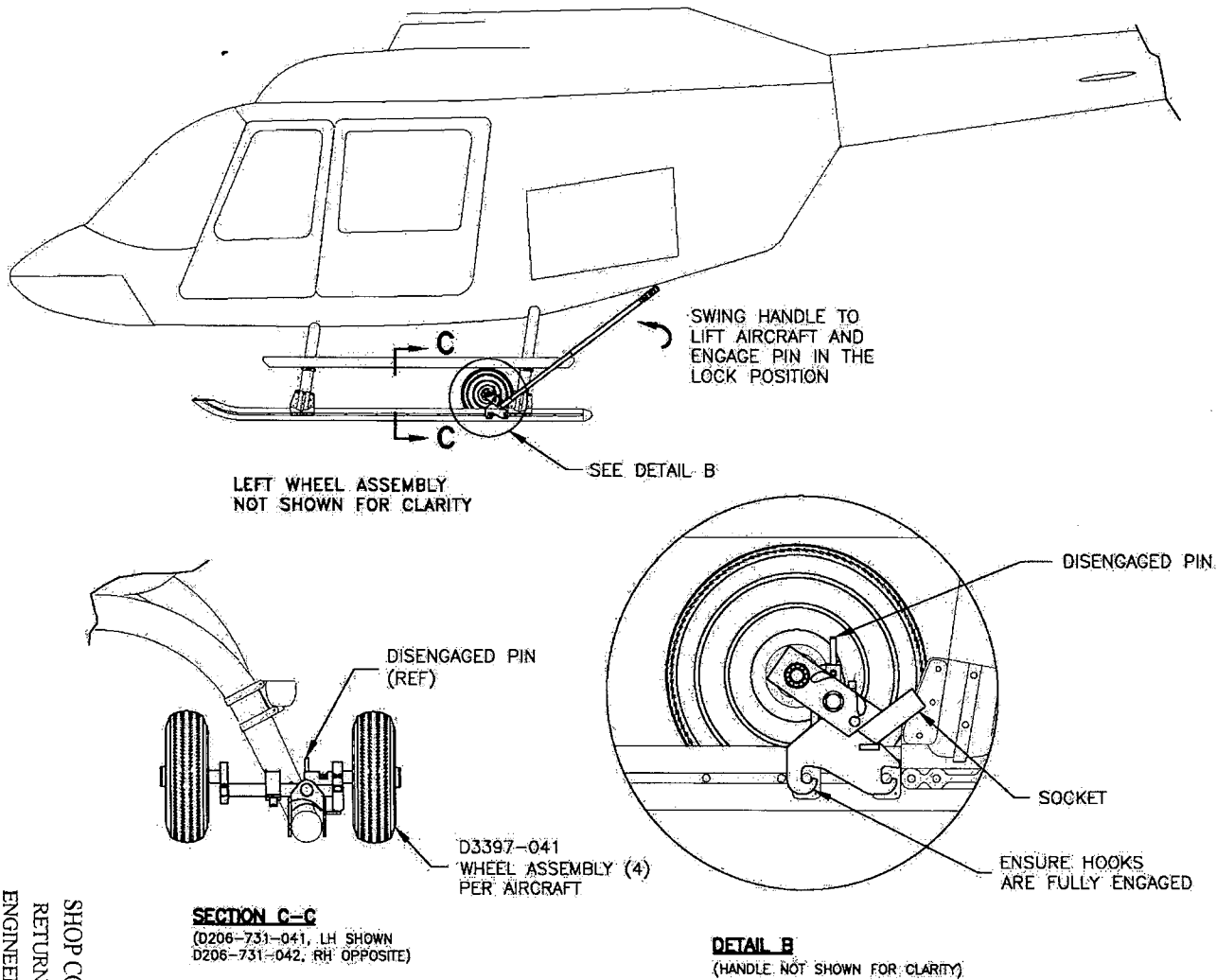
QTY -011	QTY -041	QTY -042	Part Number	Description
X			D206-731-011	MECHANICAL GROUND HANDLING WHEEL KIT
1	X		D206-731-041	MECHANICAL GROUND HANDLING WHEEL (LH)
1		X	D206-731-042	MECHANICAL GROUND HANDLING WHEEL (RH)
	1	1	D3335-5	* SPRING
		1	D3353-041	* LUG ARM WELDMENT
	1		D3353-042	* LUG ARM WELDMENT
	1		D3354-041	* LEFT ARM WELDMENT
		1	D3354-042	* MIRROR ARM WELDMENT
1			D3355-041	* HANDLE ASSEMBLY
	1	1	D3356-1	* PIN
	2	2	D3397-041	* WHEEL ASSEMBLY
1			D3381-1	** LABEL
	1	1	D3354-043	Right arm weldment
	1	1	113-800	* GREASE FITTING
	2	2	656-051	* FLAT WASHER
	1	1	663-079	* LOCK WASHER
	1	1	AN5-23A	* BOLT
	1	1	AN960JD516	* WASHER
	2	2	CP-21	* COTTER PIN
	1	1	MS21042L5	* NUT
	2	2	SNF-34	* SLOTTED NUT
	1	1	TP-2	* SLOTTED SPRING TENSION PIN
	1	1	TP-134	* SLOTTED SPRING TENSION PIN

* shown for reference only, part is included in D206-731-041/ -042 assemblies above

** shown for reference only, part is included in D3355-041 assembly above

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 NO. 25778

PRELIMINARY ISSUE



**Figure 2 – D206-731-041 Mechanical Ground Handling Wheel Installation
(Left Side Shown, Right Side Opposite)**

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Date: 05.01.26

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